

Date: Wednesday, 21/05/2008 2:29:23 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-667-203

Job Number : 39380

Estimate Number : 10804

P.O. Number :

Part Number : D206667203

This Issue : 21/05/2008 S.O. No. :

Drawing Number : REWORK-ARM.SHIELD

Prsht Rev. : NC

Project Number :

First Issue : 21/05/2008 Type : CROSSTUBES

Drawing Revision :

Previous Run : 38521

Material :

Due Date : 28/05/2008 Qty: 1 Um: Each

Written By : \_\_\_\_\_

Checked &amp; Approved By : \_\_\_\_\_

Comment : \_\_\_\_\_

Additional Product

<b>DART</b>		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL 009-09			
PN	D206-667-203A	CHG	CHG002
DESC	Crosstube Aft High	STC	SH01-5
LOT	B35028	STC	SR01304NY
MODEL	Bell 206L/L1/L3/L4	STC	
MADE IN CANADA			

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
CHG002

08.522 JLD

2.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

RTN FROM OFFSHORE INVENTORY  
1 X D206-667-203A B 35028 CHG001

ml 08 05 26

①

3.0

D206667203A

Crosstube Aft w/Armor Shield



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Crosstube Installation W/ armour shield  
B/N 35028

ml 08 05 26

①

4.0

SPRAY PAINTING

SPRAY PAINTING



Comment: REMOVE SUPPORTS, CLAMPS AND HARWARE

DISCARD HARDWARE IF NO GOOD

KEEP CLAMPS AND SUPPORTS TO  
REASSEMBLE

STRIP TUBE COMPLETELY TO  
REMOVE ARMOR SHIELD

ml 08 05 27 ①

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*080527 ①*

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*ml 080527 ①*

7.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

*080527 ①*

8.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

*NIA*

1-Install nut plates as per Dwg D206-667-243.

9.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

RE-ASSEMBLE

INDICATE ANY NEW PARTS USED:

*Abrasion strips 335900*

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

*ml 080528 ①*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Job Number: 39380

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/29 (FL)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

(12)

ENSURE ORIGINAL KIT IN BOX

Identify and pack for shipping as per PPP D206-667-203 CNG 002

Location: C

PPP Rev: C

8/5/29

SD

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/05/29 (FL)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29 (FL)

Job Completion



mf 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT) SCALE NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05-07-26

**UNDER REVIEW**

06.08.10 RH  
12-draw detail F

Plastic only

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

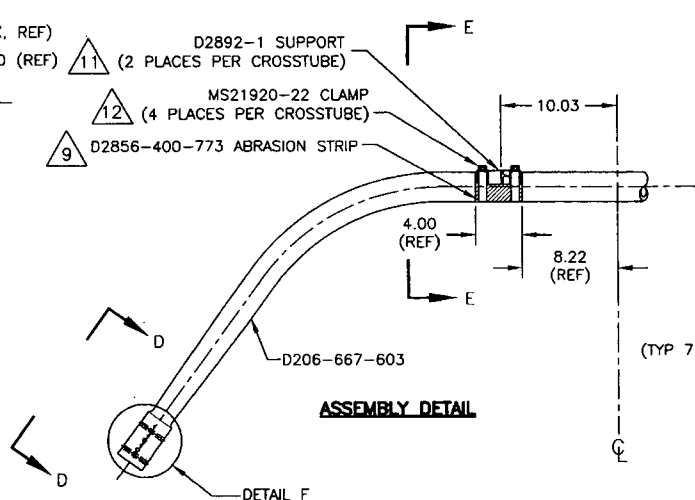
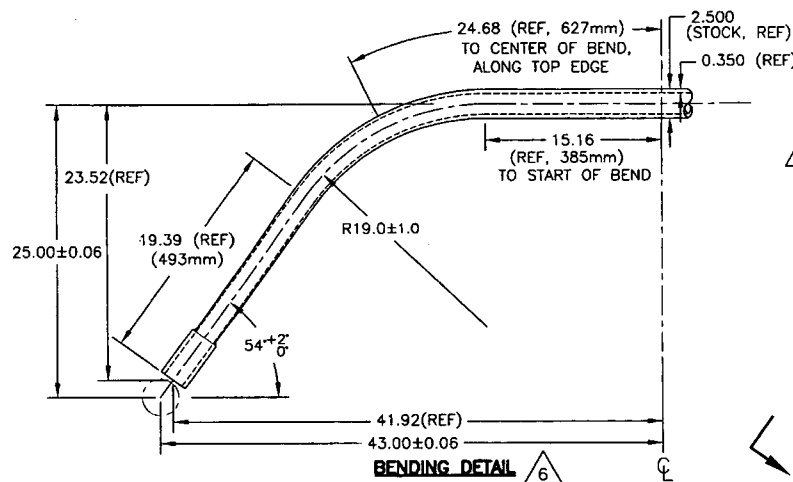
#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115  
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

w/b 39380

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**B**  $\phi 0.323^{+0.005}_{-0.000}$   
(TYP 5 PLACES PER CUFF)  
HOLE TO BE ALIGNED WITHIN  $\pm 0.001$   
OF HOLE ON OTHER SIDE OF CUFF

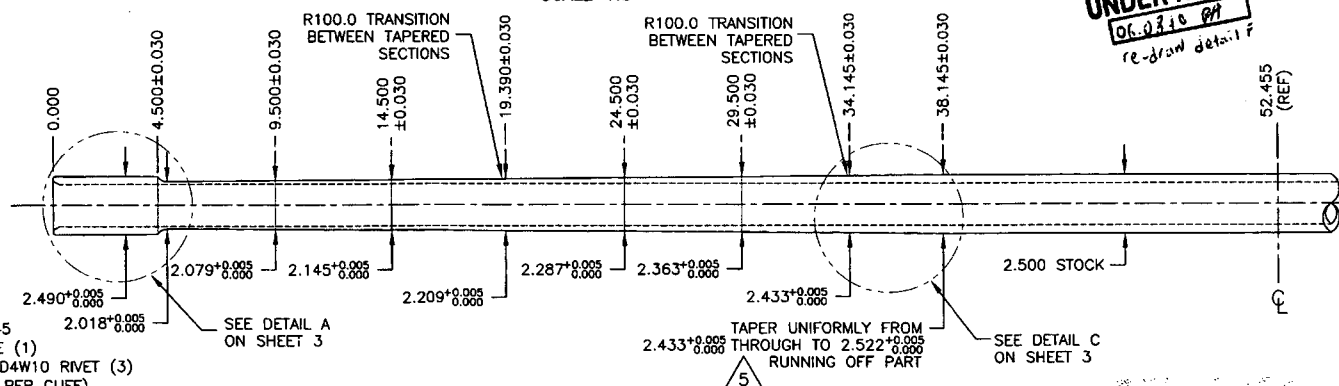
PILOT  $\phi 0.128$   
C'SINK  $\phi 0.225 \times 100'$   
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

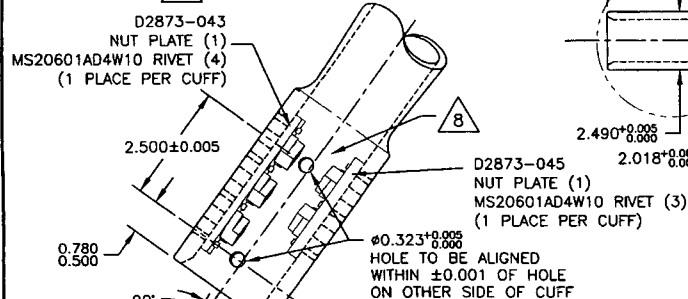
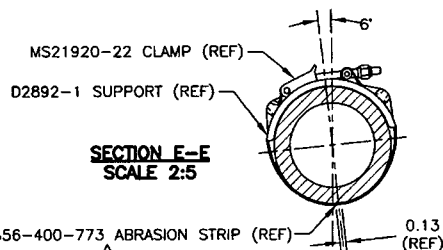
**DETAIL F**  
SCALE 2:5

**UNDER REVIEW**  
06-03-10 PH  
re-draw detail F

**TURNING DETAIL**  
SCALE 1:5



**SECTION E-E**  
SCALE 2:5



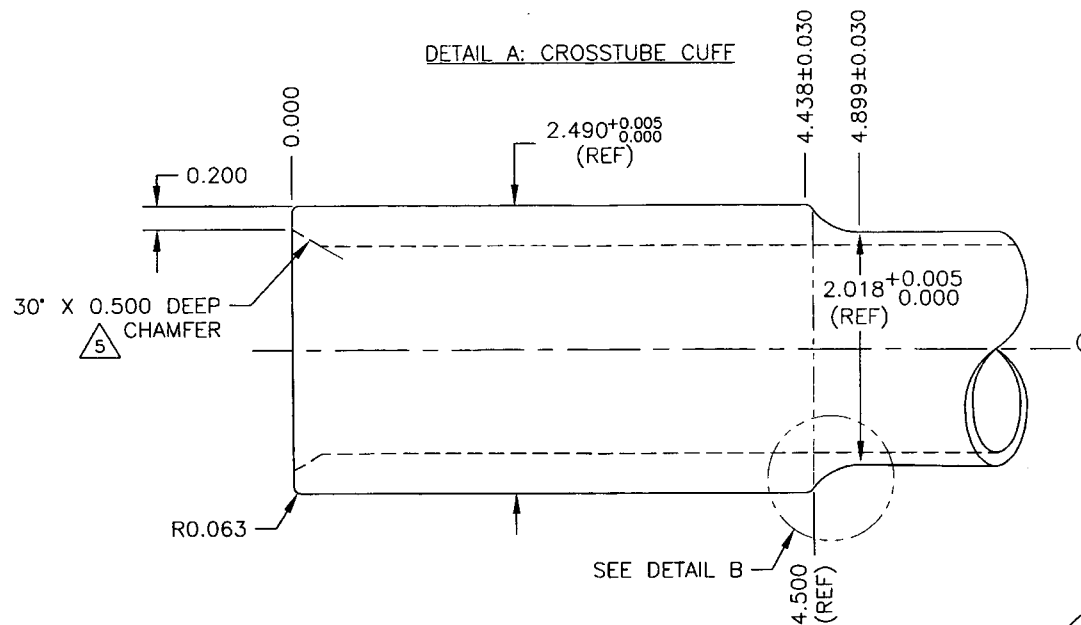
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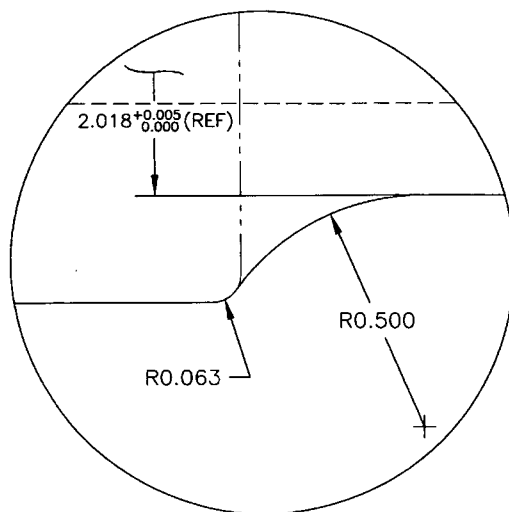
DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	DS	APPROVED	DS	DRAWING NO.	REV. B
DATE	05.07.26	TITLE	CROSSTUBE ASS'Y (206L HIGH AFT)	SHEET 2 OF 3	SCALE
					1:10



# DETAIL A: CROSSTUBE CUFF

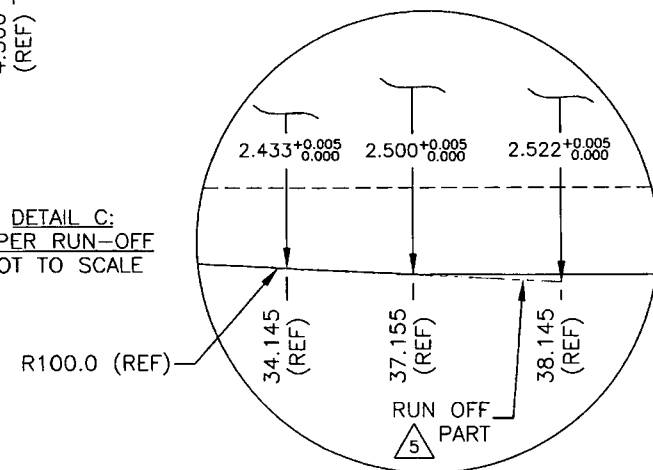


05.07.26 PH  
**UNDER REVIEW**  
 06.03.10 PH  
 re-drawn detail F



DETAIL B: CUFF  
 TRANSITION  
 SCALE 4:1

## DETAIL C: TAPER RUN-OFF NOT TO SCALE



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 PH

DRAWN BY  
 PH

**DART** DART AEROSPACE LTD.  
 HARRISBURG, ONTARIO, CANADA

CHECKED  
 DS

APPROVED  
 DS

DRAWING NO.  
 D206-667-243

REV. B  
 SHEET 3 OF 3

DATE  
 05.07.26

TITLE  
 CROSSTUBE ASS'Y (206L HIGH AFT)

SCALE  
 1:1